

Work Order ID 94321

94321

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December-07-12 10:47:47 AM

Item ID: D412-706-011

Accept

N900040100

Setup Start ***NS1***

Revision ID:

Stop ***NS2***

Item Name: Fuel Purge Canister

Start Date: 12/07/12 Start Qty: 2.00

2

Cust Item ID:

Required Date: 12/07/12 Req'd Qty: 2.00

2

Customer:

Reference: rework - ecn12-678

Approvals: Process Plan: *[Signature]*

Date:

Tooling:

Date:

Run Start ***NR1***

QC:

Date:

SPC (Y/N):

Date:

Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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Draw Nbr	Revision Nbr
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IIN-D412-706	B
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100

0.00

100

DOCUMENT CONTROL

DC

Memo

0.00

Document Control

Photocopy bluefile and create labels per PPP D412-706-011 CHG004

110

Pick Kit

0.00

110

Packaging

Memo

0.00

Packaging

PULL FROM STOCK:

1 X D412-706-011 B85238

1 X D412-706-011 B87407

REMOVE FROM KITS:

1EA X AN832-6D B

1EA X D3297-3-0085 B

RETURN TO STOCK

ADD TO KITS:

1EA X D3297-1-0121 B

DART AEROSPACE		1270 ABERDEEN ST HAWKESBURY ON CANADA K6A 1K7 TEL: 1-613-632-5200 www.dartae.com	
PATENT	N/A	CHG	CHG003
P/N	D412-706-011	STC	SH04-54
DESC.	Fuel Purge Canister	STC	SR02055NY
LOT	B85238	STC	
MODEL	Bell212/412		
TC APPROVAL # 09-89		MADE IN CANADA D2729-4	

Work Order ID 94321

94321

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December-07-12 10:47:47 AM

Item ID: D412-706-011 Accept ***N900040100*** Setup Start ***NS1***
 Revision ID: Stop ***NS2***
 Item Name: Fuel Purge Canister
 Start Date: 12/07/12 Start Qty: 2.00 ***2*** Cust Item ID:
 Required Date: 12/07/12 Req'd Qty: 2.00 ***2*** Customer:
 Reference: rework - ecn12-678

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start ***NR1***
 QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
120 *120* QC Quality Control	QC4- 100% Inspect kits for completeness Memo	0.00 0.00							
130 *130* Packaging Packaging Packaging	Packaging Memo REPACKAGE USING NEW B/N AT CHG 004 Identify and pack for shipping as per PPPD412-706-011 Location: <i>P6022</i> PPP Rev: _____	0.00 0.00							
140 *140* QC Quality Control	QC21- Final Inspection - Work Order Release Memo	0.00 0.00							

DART
 Dart Aerospace Ltd.
 1270 ABERDEEN ST.
 HAWKESBURY, ONT CANADA K6A 1K7

TC APPROVAL # 09-89
 TEL: 1-813-632-5200

P/N	D412-706-011	CHG	CHG003
DESC.	Fuel Purge Canister	SIC	SH04-54
LOT	B87407	SIC	SR04055NY
MODEL	Bell 212/412	SIC	

PATENTS: US #5735482, CA #2222163
 EUROPEAN NO. 2-0828555 MADE IN CANADA 027292

Picklist Print

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Page 1

Work Order ID: 94321

Parent Item: D412-706-011

Parent Item Name: Fuel Purge Canister

Start Date: 12/07/12

Required Date: 12/07/12

Start Qty: 2.00

Required Qty: 2.00

Comments: IPP Rev:E 04.12.03 Remove AN6289-6D; Change Qty of 924-6DKJ/JLM
 IPP Rev:F 08-05-14 revise comment in seq.17/24 DD ver:EC IPP rev G 10.01.18 per DSI9494 EC verified by:DD IPP Rev:H 10.03.23 as per IIN revA DD verified by:EC IPP Rev:I 10.05.10 as per chg003 DD verified :EC IPP REV K 11.06.17 AS PER CHG 002 JLM VERIFIED BY:ec IPP Rev:L 12.12.07 as per IIN revB DD verified by:JLM

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
AN832-6D UNION		Purchased	No				Each	25.0000		-2			
				<u>Location</u>		<u>Loc Qty</u>		<u>Loc Code</u>					
				ST324		25							
				120693		25							
D3297-1-0121 HOSE ASS'Y		Manufactured	No				Each	8.0000		2			
				<u>Location</u>		<u>Loc Qty</u>		<u>Loc Code</u>					
				ST192		8							
				82745		3							
				91829		1							
				93172		4							
D3297-3-0085 HOSE ASS'Y		Manufactured	No				Each	7.0000		-2			
				<u>Location</u>		<u>Loc Qty</u>		<u>Loc Code</u>					
				ST191		7							
				77599		2							
				86917		1							
				87653		4							
D412-706-011 Fuel Purge Canister		Manufactured	No				Each	0.0000		2			

m/20693

93172

77599 -1
86917 -1

8523814
87407 14

Status	Item ID	Rev	Name	Start Date	Quantity	UOM	Proj Date	Sec	Trap	ip	Quam	mmend	N:C	ISort	me	Offse	n Ty	Per	Cch	to	ore	Cs	Last	Id	Da
	AN3-5A	/	Bolt	1/01/08	4....	Ea		110	0	0.0...				20	0	M...							6/1...	12	
	AN814-8D	/	Plug	6/16/11	1....	Ea		110	0	0.0...				21	0	M...							6/1...	6/	
	AN815-6D	/	Union-M-Flare	3/23/10	2....	Ea		110	0	0.0...				22	0	M...							6/1...	3/	
	AN815-8D	/	Union-M-Flare	5/10/10	1....	Ea		110	0	0.0...				23	0	M...							6/1...	5/	
Remove	AN832-6D	/	UNION	1/01/08	1....	Ea		110	0	0.0...				24	0	M...							6/1...	12	
	AN833-6D	/	Elbow, Bulkhead...	3/23/10	1....	Ea		110	0	0.0...				25	0	M...							6/1...	3/	
	AN833-8D	/	ELBOW	5/10/10	1....	Ea		110	0	0.0...				26	0	M...							6/1...	5/	
	AN924-6D	/	Nut	3/23/10	4....	Ea		110	0	0.0...				27	0	M...							6/1...	3/	
	AN924-8D	/	NUT	5/10/10	1....	Ea		110	0	0.0...				28	0	M...							6/1...	5/	
	AN938-6D	/	Tee	6/01/10	1....	Ea		110	0	0.0...				29	0	M...							6/1...	6/	
	AN960JD10	/	Washer	1/01/08	8....	Ea		110	0	0.0...				31	0	M...							6/1...	12	
	AN960JD10L	/	Washer	1/01/08	4....	Ea		110	0	0.0...				30	0	M...							6/1...	12	
	AN960JD916	/	WASHER	9/30/09	2....	Ea		110	0	0.0...				32	0	M...							6/1...	12	
	D2001-4	/	Valve Assembly (1...	12/05/09	1....	Ea		110	0	0.0...				1	0	M...							6/1...	12	
	D3262-043	/	Canister Assembly	5/10/10	1....	Ea		110	0	0.0...				2	0	M...							6/1...	5/	
	D3264-1	/	Bracket	12/05/09	2....	Ea		110	0	0.0...				3	0	M...							6/1...	12	
	D3297-1-0098	/	HOSE ASS'Y	12/05/09	1....	Ea		110	0	0.0...				4	0	M...							6/1...	12	
	D3297-3-0085	/	HOSE ASS'Y	12/05/09	1....	Ea		110	0	0.0...				5	0	M...							6/1...	12	
	D3297-3-0210	/	HOSE ASS'Y	12/05/09	1....	Ea		110	0	0.0...				6	0	M...							6/1...	12	
	D3298-005	/	Tube Assembly	12/05/09	1....	Ea		110	0	0.0...				9	0	M...							6/1...	12	
	D3298-007	/	Tube Assembly	12/05/09	1....	Ea		110	0	0.0...				10	0	M...							6/1...	12	
	D3299-3	/	Fitting	12/05/09	1....	Ea		110	0	0.0...				13	0	M...							6/1...	12	
	D3299-5	/	Fitting	12/05/09	1....	Ea		110	0	0.0...				14	0	M...							6/1...	12	
	D3299-7	/	Fitting	5/10/10	1....	Ea		110	0	0.0...				12	0	M...							6/1...	5/	
	D3301-1	/	Placard	12/05/09	1....	Ea		110	0	0.0...				15	0	M...							6/1...	12	
	D3301-3	/	Placard	12/05/09	1....	Ea		110	0	0.0...				16	0	M...							6/1...	12	
	D3302-1	/	Doubler	12/05/09	1....	Ea		110	0	0.0...				17	0	M...							6/1...	12	

Status		Item ID	Rev	Name	Start Date	Quantity	UOM	Drop Date	Secrap	ip	Quam	end	N/C	IL	Sort	me	Off	in	Ty1	Per	Cch	to	ore	C3	Last	Id	D3
		D3302-3 ✓		Doubler	12/05/09 ✓	1....	Ea		110	0	0.0...				18	0	M...								6/1...	12	
		D3329-1 ✓		Bushing	12/05/09 ✓	2....	Ea		110	0	0.0...				19	0	M...								6/1...	12	
		D4054-001 ✓		Tube Assembly	5/10/10 ✓	1....	Ea		110	0	0.0...				7	0	M...								6/1...	5/	
		D4054-003 ✓		Tube Assembly	5/10/10 ✓	1....	Ea		110	0	0.0...				8	0	M...								6/1...	5/	
		D4054-009 ✓		Tube Assembly	5/10/10 ✓	1....	Ea		110	0	0.0...				11	0	M...								6/1...	5/	
		MS21042L3 ✓		Nut	1/01/08 ✓	4....	Ea		110	0	0.0...				33	0	M...								6/1...	12	
		MS21919-WDG9 ✓		Clamp	1/01/08 ✓	2....	Ea		110	0	0.0...				34	0	M...								6/1...	12	
		MS21920-42 ✓		CLAMP(per MIL-D...	1/01/08 ✓	2....	Ea		110	0	0.0...				34	0	M...								6/1...	12	
		MS29512-06 ✓		O-RING	5/10/10 ✓	7....	Ea		110	0	0.0...				35	0	M...								6/1...	5/	
		MS29512-08 ✓		O-RING	5/10/10 ✓	3....	Ea		110	0	0.0...				36	0	M...								6/1...	5/	
		MS35489-16 ✓		GROMMET	6/16/11 ✓	1....	Ea		110	0	0.0...				37	0	M...								6/1...	6/	

ENGINEERING CHANGE NOTICE

DART AEROSPACE LTD

Date: 12.11.16	Job No.: ENG 3106	ADR Yes/No: N	ADR Date:	ECN #: 12- 678
Product No.: D412-706		Created By: RF	Approved By:	
Product Name: Fuel Purge Canister Installation		Checked By:		

Distribution	Reqd	Resp	Initial / Date (YY/MM/DD)
Director of Operations	Y	JLM	
Production Manager / Coord.	Y	JLM	
Purchasing Coord.	N	CL	
Production Engineering Coord.	Y	DD	
Production Engineering Coord.	N	JLM	
Customer Order Processing	N	RM	

Distribution	Reqd	Resp	Initial / Date (YY/MM/DD)
DQA / QA Coord.	Y	PS	
QC Coordinator	Y	ED	
Customer Support	Y	SW/LM	
Customer Technical Support	Y	MB/DS	
Marketing	Y	HM	

Reason for Change: Revise documentation per PAR12-184

Documents Affected:
 IIN-D412-706 Rev. B
 ICA-D412-706 Rev. 1
 MDL-D412-706 Rev. A

PAPERWORK UPDATE ☒ PARTS MUST COMPLY ☒ PREVIOUS PARTS SATISFACTORY ☐

#	Quality Assurance Actions	Reqd	Resp	Notes	Complete
1	Notify Previous Customers	N			
2	Notify Eurocopter France	N			
3					

#	Engineering Actions	Reqd	Resp	Notes	Complete
4	Required Documents/Drawings Under Review	N			
5	Update Master Document List (MDL)	Y	RF	MDL-D412-706 Rev. A	12.12.06
6	Update Product Compatibility Matrix	N			
7	Create Eurocopter Form (FEE)	N			
8	Notify TC / FAA of Change	N			
9					

#	Document Control Actions	Reqd	Resp	Notes	Complete
10	Move Electronic Files/Design Journal	Y	KJ		
11	Update Product Specification Files	Y	KJ		12.12.06
12	Update Approved/Preliminary Dwg PDF Files	N			
13	Update Document Record (DR)	N			
14	Update Product Development Summary	N			
15	Update QSI 021 and/or STC Approval List	N			
16	Create/Update Parts / STC Database	N			
17	Update / Verify ARC Database	N	RF		
18	Create / Update Change Record Form / Item Card Database	Y	KJ	SEE BELOW	12.12.06
19	Create / Update PPP's	Y	KJ		12.12.06
20	Red Decals required?	N			
21	Update Document Control Database / Laminated Dwgs	N			
22	Update Grey Project / Electronic Binder PDF Files	Y	KJ		12.12.06
23	Update D-Part/M-Drawing/DSI/DEO Master Binders	N			
24					

Description / Action:
 Update BOM/routing FOR -011/-013/-015 per IIN-D412-706 Rev. B
 D412-706-011 @ CHG 004; D205-706-013 @ CHG 003
 Ensure -011/-013 kits in stock/in progress are updated per part list from IIN-D412-706 Rev. B

ECN Verified & Complete: _____ Date: _____

5. PARTS LIST

Qty -011	Qty -013	Qty -015	Part Number	Description
X			D412-706-011	FUEL PURGE CANISTER INSTALLATION (212/412)
	X		D205-706-013	FUEL PURGE CANISTER INSTALLATION (205/214/EAGLE SINGLE)
		X	D204-706-015	FUEL PURGE CANISTER INSTALLATION (204)
1	1	1	D2001-4	VALVE ASSEMBLY
	2	2	D2026-101	SCREW
	1	1	D3262-041	CANISTER ASSEMBLY
			D3262-043	CANISTER ASSEMBLY
2	2	2	D3264-1	BRACKET
1			D3297-1-0098	HOSE ASSEMBLY
1	1		D3297-1-0121	HOSE ASSEMBLY
1	1		D3297-1-0130	HOSE ASSEMBLY
1			D3297-3-0210	HOSE ASSEMBLY
	1		D3297-3-0350	HOSE ASSEMBLY
		1	D3297-5-0410	HOSE ASSEMBLY
1	1		D3298-001	TUBE ASSEMBLY
1			D3298-005	TUBE ASSEMBLY
1			D3298-007	TUBE ASSEMBLY
	1		D3298-009	TUBE ASSEMBLY
		1	D3298-011	TUBE ASSEMBLY
		1	D3298-013	TUBE ASSEMBLY
		1	D3298-015	TUBE ASSEMBLY
	1	1	D3299-1	FITTING
1			D3299-3	FITTING
1			D3299-5	FITTING
1			D3299-7	FITTING
1	1	1	D3301-1	PLACARD
1	1	1	D3301-3	PLACARD
1	1		D3302-1	DOUBLER
1	1		D3302-3	DOUBLER
		1	D3302-5	DOUBLER
		2	D3302-7	DOUBLER
2			D3329-1	BUSHING
1			D4054-001	TUBE ASSEMBLY
1			D4054-003	TUBE ASSEMBLY
1			D4054-009	TUBE ASSEMBLY
4	4	4	AN3-5A	BOLT
			AN814-6D	PLUG
1	1		AN814-8D	PLUG
2	2	2	AN815-6D	UNION
1			AN815-8D	UNION
		1	AN816-6D	NIPPLE
2	3	1	AN833-6D	ELBOW

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Revision: B

Date: 12.11.06

Qty -011	Qty -013	Qty -015	Part Number	Description
1			AN833-8D	ELBOW
		1	AN919-6D	REDUCER
4	4	1	AN924-6D	NUT
1			AN924-8D	NUT
1			AN938-6D	TEE
4	4	2	AN960JD10L	WASHER
8	8	8	AN960JD10	WASHER
2	2		AN960JD916	WASHER
4	4	4	MS21042L3	NUT
	1	1	MS21919WDG12	CLAMP
	2		MS21919WDG16	CLAMP
		2	MS21919WDG6	CLAMP
		3	MS21919WDG7	CLAMP
2	5		MS21919WDG9	CLAMP
2	2	2	MS21920-42	CLAMP
7	5	5	MS29512-06	O-RING (OR M83248/1-906)
3			MS29512-08	O-RING (OR M83248/1-908)
	1	1	MS35489-11	GROMMET
1			MS35489-16	GROMMET

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